

Date: Thursday, 10/04/2008 4:00:39 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 38540  
 Estimate Number : 10262  
 P.O. Number :  
 This Issue : 10/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LANDING GEAR  
 Previous Run : 38459  
 Written By :  
 Checked & Approved By : JD 08.4.10  
 Comment : Est Rev: I 02.09.25 Rearranged procedure steps KJ  
 Est Rev: J 06-03-23 As per Rev D JLM  
 Est Rev: K 06-07-13 As per dsi9343 EC  
 Est Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By: EC

Part Number : D350636011  
 Drawing Number : D2750 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 05/05/2008 Qty: 1 Um: Each

POSITIVE  
RECALL

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



5086123  
W

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003 004 per DSI943

2.0

D26003BENT



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

B 38463

D

W

8-5-5

3.0

D2744



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Cap

Batch:

B37768

BE 08/05/06

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

W  
8-5-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/04/2008 4:00:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

as per dwg D2750.

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open up holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

\*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\* Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750, and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m106330 / m107877* *BE 08/05/06*

10-Grind welds flush as per Dwg D2750 *7-5-6*

12- Scribe batch# inside per dwg D2750 *7-5-5*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *8-08/05/06 (X)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *8-08/05/06 (X)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *7-5-6 (1)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *8-08/05/06 (X)*

9.0

D2739



Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s)

Web

Batch: *33753*

*(1)*

*8-5-6*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 4:00:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	D34901	
------	--------	--



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *R33824*

*RF 08/05/08*

11.0	D34903	
------	--------	--



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Crossbolt spacer

Batch: *R33825*

*RF 08/05/08*

12.0	D2743	
------	-------	--



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Crossbolt Spacer

Batch: *R32656*

*RF 08/05/08*

13.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
------	-------------	----------------------



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on  
sheet 4)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *M107304*

exp. date: *8-10-1*

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

*RF 3-5E*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/04/2008 4:00:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

A/R Aluminum Rod batch: *M107263 BE 08/05/08*

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*5 08/05/08 (+)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/05/08 (+)*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*FL 08/05/08*

B 38540

17350636011

09/05/2008

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*HL 08-05-09*

S.225 07.55

#1 321.2 F

#2 30 F

#3 -MIN F

#4 F

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*FL 08/05/22 (+)*

19.0

ALS41032225



Comment: Qty.: 42.00000 Each(s)/Unit Total: 42.00000 Each(s)

Insert

Batch: *M100489*

*FL*

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

*FL 08/05/22 (+)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	D2745	Bushing
------	-------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch:

B37303

(x3)

B36230 (x5)

FL

22.0	D353525	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38162

FL

23.0	D353625	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B38565

FL

24.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 3/2.0000 Each(s)/Unit Total : 3/2.0000 Each(s)

WEARPAD

Batch:

B37749

FL

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39279

FL

26.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39277

FL

27.0	D37911	Wearplate
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39276

FL 08/05/22

①

Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D37943

Gasket



\* Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Gasket B39361 ~~B39278~~

FL

29.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Wearshoe B39278

FL

30.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Phenolic Washer B34470

FL

31.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Screw m15072

FL

32.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Screw m108079

FL

33.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
WASHER B38139  
Batch:

FL

34.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Blade Fitting, LH  
Batch: B38465

FL

35.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
PLUG ASSEMBLY  
Batch: B38756

FL 05/05/22

①

Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

36.0 D3492043 Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1538563

FL

37.0 AN3C5A Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: m107737

FL

38.0 AN3C6A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m105300

FL

39.0 AN3C7A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m101376

N/A

40.0 AN6C44A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m107685

FL

41.0 AN8C35A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: m106896

FL

42.0 AN960C10L washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: m107971

FL 08/05/22 ①

Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

43.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
WASHER

\* Batch: m106513 (x1) m107520 (x1) FL

44.0	MS210436	NUT
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
NUT

Batch: m107736 FL

45.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
NUT

Batch: m107756 FL

46.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
WASHER

Batch: m107394 FL

47.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
WASHER

Batch: AD107587 FL

48.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: m106096

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750  
SIKA FLEX 241

BATCH: m107804  
EXP DATE: 08/10

FL  
08/05/22

①

Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch:

M106096

F2 08/05/22

①

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/22 (20)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 36343

52.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107876

53.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107820

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107881

55.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 107939

S 8/0/23 ①

Date: Friday, 16/05/2008 9:24:42 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38540

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B 38102

57.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: B 38161

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



RECALL  
TIVE 08/05/23 AUTH  
RELEASED LL DATE 08/05/23

MF 08-05-23

38540



**DART**

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 2 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS	

GENERAL NOTES:**RELEASED**  
*07-08-02 [Signature]*

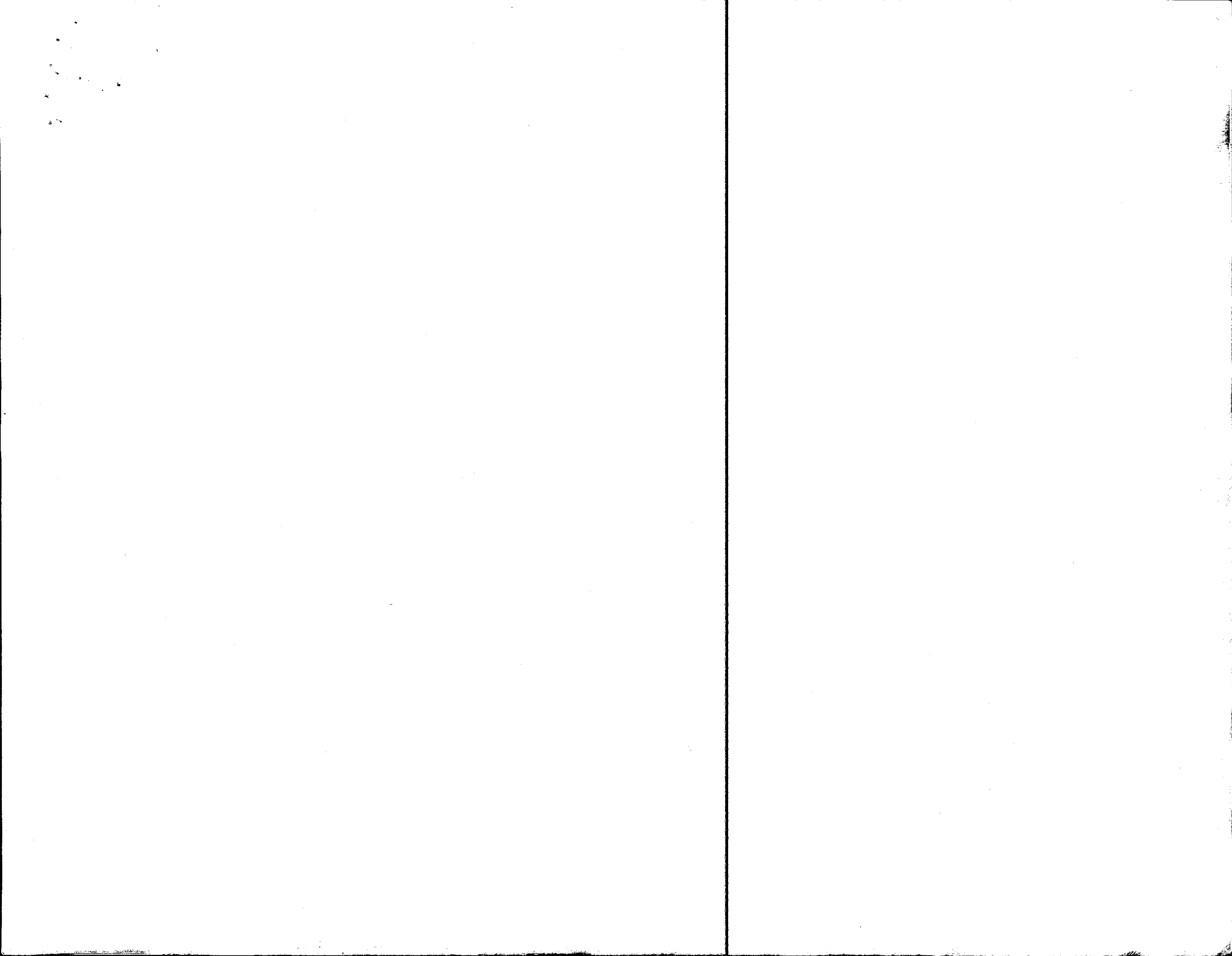
1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

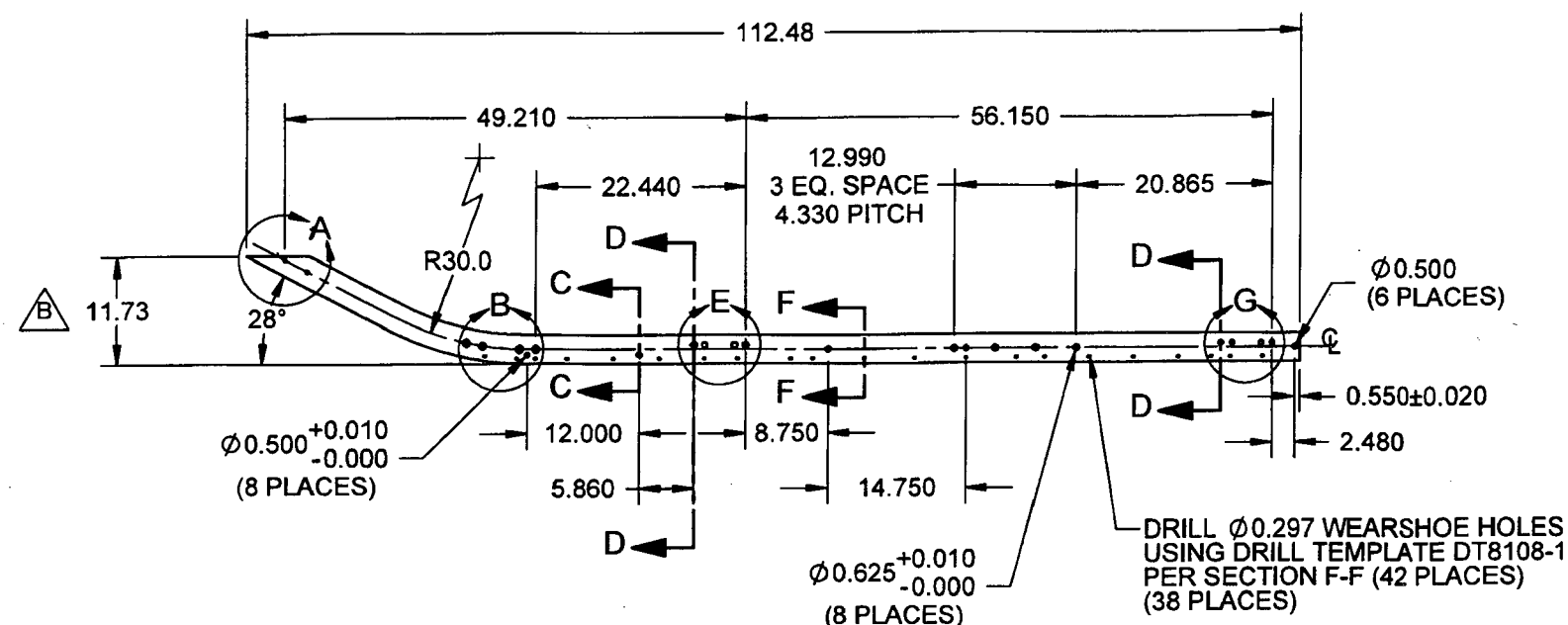
SHOP COPY  
FINISH TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *38540*

**COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.**

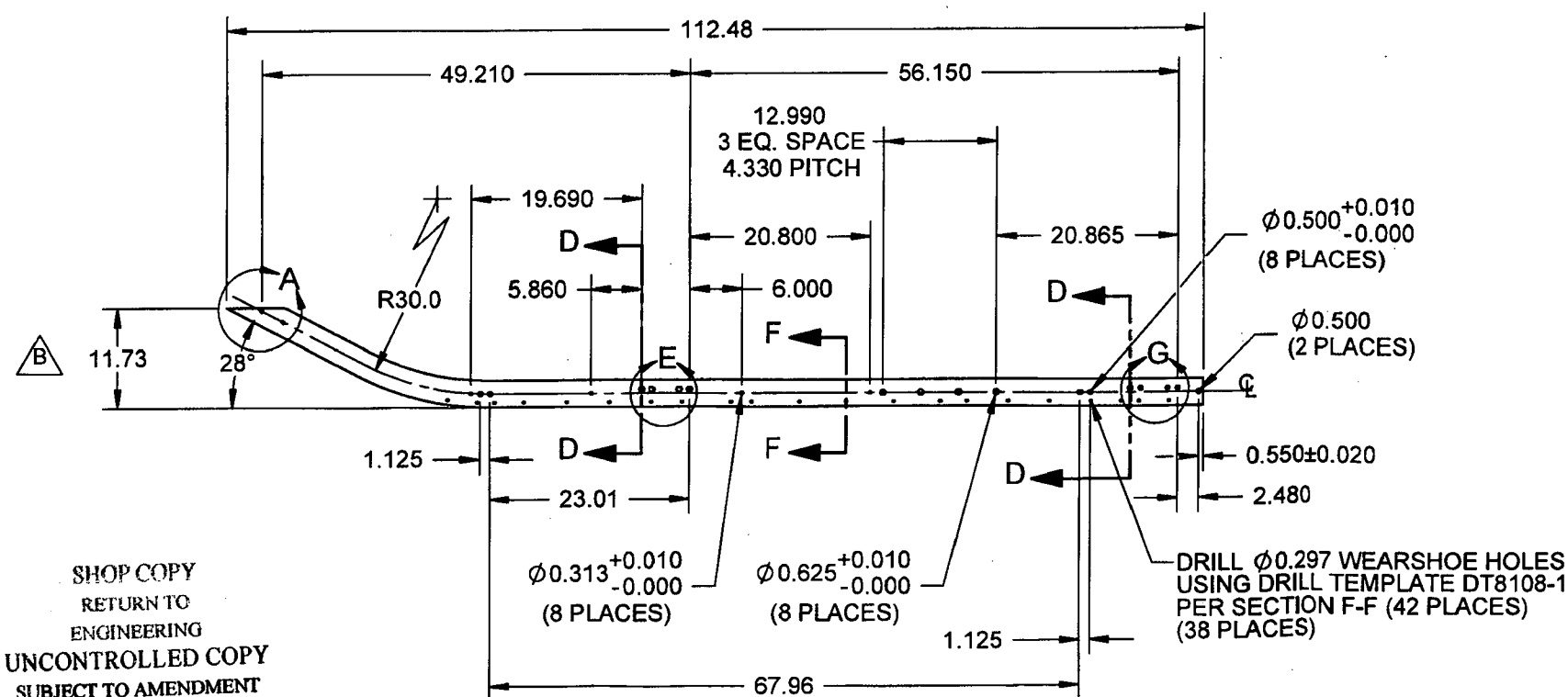
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



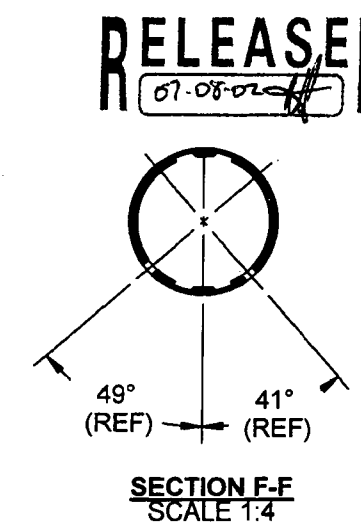
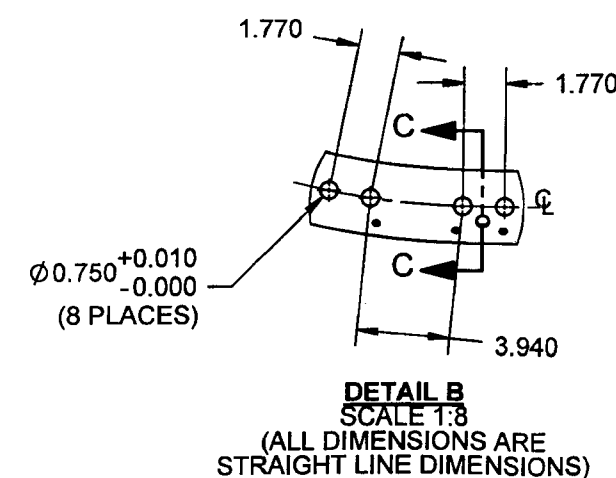
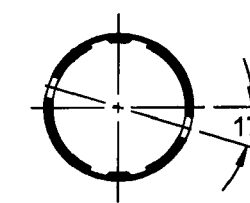
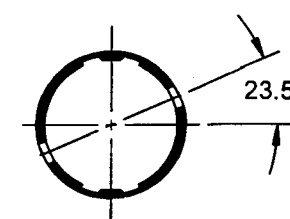
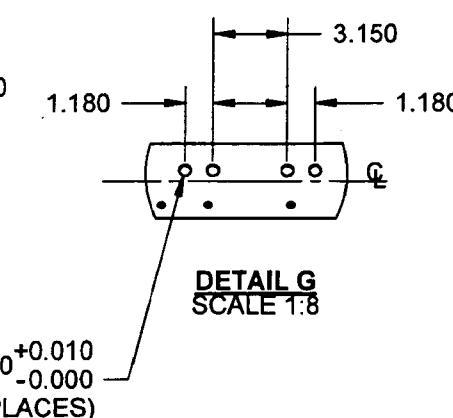
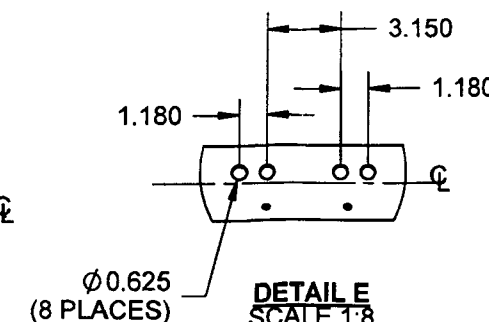
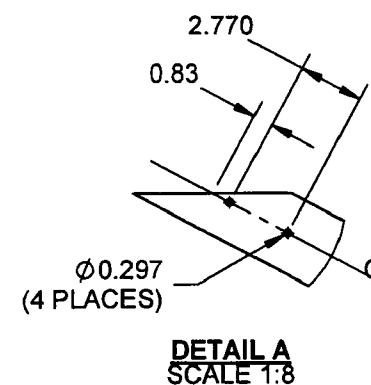





**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38540

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



INSTALL ALS4-1032-225  
INSERTS (4 PLACES)  
AFTER FINISH

D2750-1 (LH) OR  
D2750-2 (RH)

**D2750-041 ASSEMBLY (SHOWN)  
D2750-042 ASSEMBLY (OPPOSITE)**

BLACK ANTI-SKID

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

2.0  
(TYP)

1.78 (REF)  
(TO D2739 WEB)

D3488-041  
(OR D3488-042)

INSTALL ALS4-1032-225  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

NO INSERT

WELDED SPACER  
NOT REQUIRED

D3535-35  
D3536-35

AN3C7A BOLT (REF)

**RELEASED**  
07.08.02

D2744 CAP

**DETAIL H**  
SCALE 1:5

INSTALL:  
AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

**SECTION J-J**  
SCALE 1:5

INSTALL AT AFTMOST  
D3537-1 WEARPAD:  
AN3C7A BOLTS (1)  
AN960C10L WASHER (1)  
(4 PLACES)

INSTALL:  
AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
(38 PLACES)

**SECTION N-N**  
SCALE 1:5

D2743 SPACER (REF)

**SECTION M-M**  
SCALE 1:5

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D2743 SPACER  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) DRILL OUT SPACER TO  $\phi 0.484$   
6) SPOT FACE  $\phi 0.750$  (SECTION P-P ONLY)

INSTALL:  
AN6C44A BOLT (1)  
D2745 BUSHING (2)  
D3631-1 WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)

**SECTION Q-Q**  
SCALE 1:5

INSTALL:  
AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

**SECTION R-R**  
SCALE 1:5

**WELDING INSTRUCTIONS**  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D3490-1 SPACER (4 PLACES) INTO  
 $\phi 0.500$  HOLES OR INSERT D3490-3 SPACER  
(4 PLACES) INTO  $\phi 0.750$  HOLES  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)  
INTO D3490-1 SPACER OR INSERT D3492-043  
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER  
ON BOTH ENDS AFTER FINISH

**SECTION K-K**  
(FOR  $\phi 0.750$  HOLES ONLY)  
SCALE 1:5

D3490-3 SPACER


INSTALL:  
D3492-043 PLUG  
ASSEMBLY  
(2 PLACES)

D3490-1 SPACER

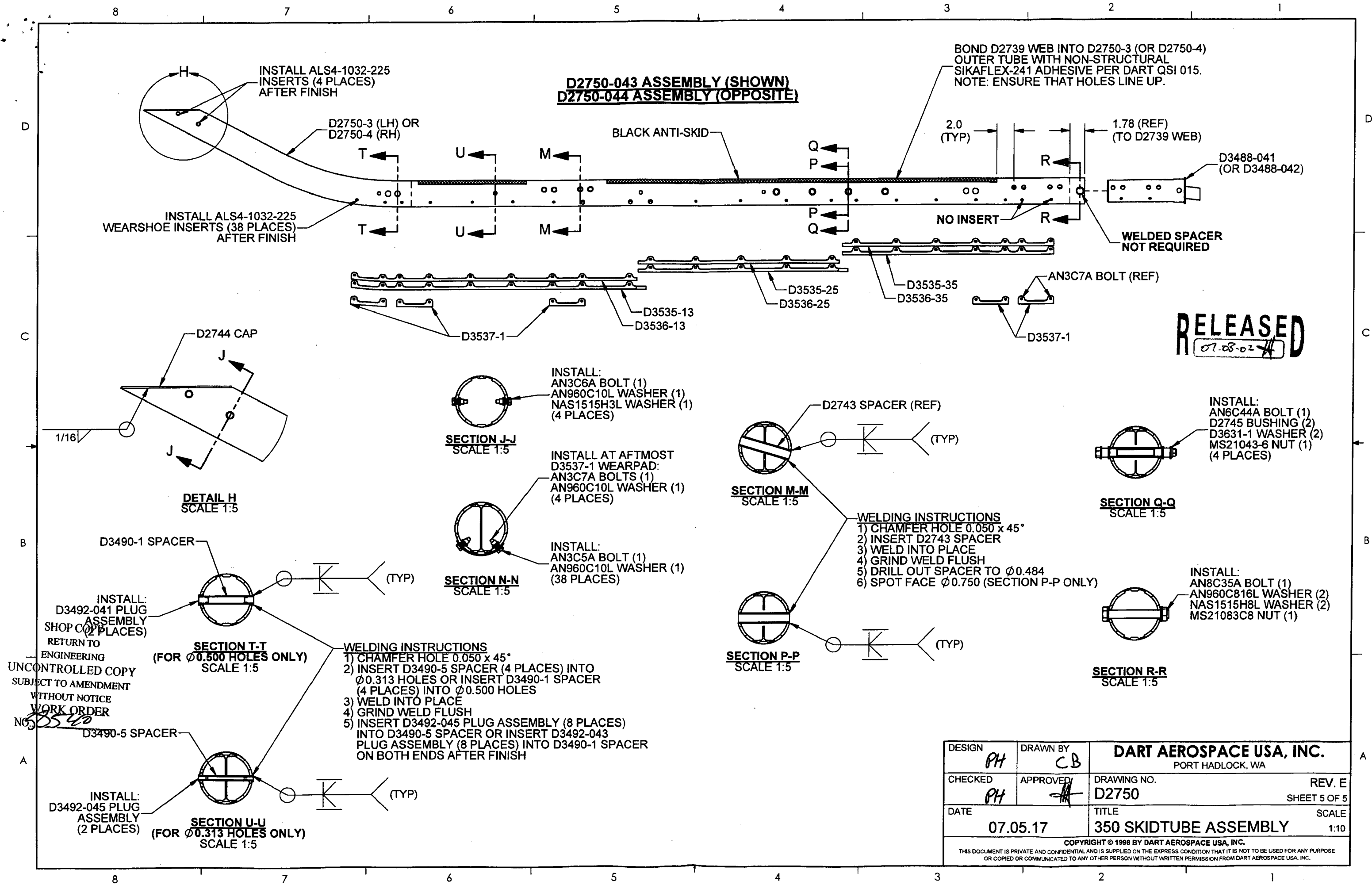
INSTALL:  
D3492-041 PLUG  
ASSEMBLY  
(2 PLACES)

**SECTION L-L**  
(FOR  $\phi 0.500$  HOLES ONLY)  
SCALE 1:5

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 138540

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED 	DRAWING NO. D2750	REV. E SHEET 4 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			







NO. 153

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 38543  
Part number: D350 636 011  
Description: 2nd tube 350  
Welding Process: Tig[ ☒ ] Mig[ ]  
Base material: Aluminium  
Current: AC[ ☒ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]  
pass[ ☒ ] fail[ ]

Qualifier Det Duval Date of Test Coupon 08-05-07

Welder Det Barclay Elliot Date of Test Coupon 08-05-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld